

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.

THIS PAGE BLANK (USPTO)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
18 July 2002 (18.07.2002)

PCT

(10) International Publication Number
WO 02/055115 A1

(51) International Patent Classification⁷: **A61L 9/01**,
9/014, 9/16, A61K 7/32, A01K 1/00

IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

(21) International Application Number: PCT/US01/42060

(22) International Filing Date:
6 September 2001 (06.09.2001)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
60/232,151 7 September 2000 (07.09.2000) US

(71) Applicant (for all designated States except US): **SOLUTIONIA INC.** [US/US]; 575 Maryville Centre Drive, St. Louis, MO 63141 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **HOCHWALT, Mark, A.** [US/US]; 457 Whitestone Farm Drive, St. Louis, MO 63107 (US). **TREHY, Michael, L.** [US/US]; 11155 Crickett Hill Drive, St. Louis, MO 63146 (US).

(74) Agent: **GOETZ, Kenneth, D.**; Lathrop & Gage, LC, Suite 2800, 2345 Grand Boulevard, Kansas City, MO 64108 (US).

(81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.

(84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE,

Declarations under Rule 4.17:

— as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii)) for the following designations AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)

— as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii)) for the following designations AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)

— of inventorship (Rule 4.17(iv)) for US only

— of inventorship (Rule 4.17(iv)) for US only

Published:

— with international search report

— before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: COMPOSITIONS AND METHODS FOR REDUCING ODOR

(57) Abstract: Novel compositions and methods for reducing odor. The composition comprises at least one synthetic zeolite, at least one acid and at least one substance selected from a metal oxide, metal, or salt of a metal or metal oxide. A wide range of odors, including ammonia and sulfurous odors, may be controlled by contacting an effective amount of the above composition with the article, substance or environment that emits the undesired odor. The composition may also be incorporated into other substances for odor reduction or control to form odor-controlled articles.



WO 02/055115 A1

COMPOSITIONS AND METHODS FOR REDUCING ODOR

FIELD OF THE INVENTION

5 This invention relates to compositions and methods effective for reducing odor. In one embodiment, this invention relates to compositions and methods effective for reducing a wide range of odors using an effective amount of a composition(s) comprising effective amounts of at least one acid, at least one
10 synthetic zeolite and at least one metal, metal oxide, or salt of a metal or metal oxide.

BACKGROUND OF THE INVENTION

 Odors offensive to the human olfactory system originate from a variety of sources including humans and animals, such as pet and animal wastes, and from activities, such as from cooking and from tobacco smoke. Some of these offensive
15 odors can be attributed to odors from specific chemicals like methyl mercaptan, hydrogen sulfide, methyl sulfide, methyl disulfide, trimethylamine, acetaldehyde, n-butyric acid, n-valeric acid, iso-valeric acid and propionic acid and the like. Many of these aforementioned chemicals can arise from partial decomposition of animal and plant wastes. Other odors that are sometimes found to be offensive to the human
20 olfactory system can originate from foods such as garlic and onions either when such foods are fresh or stale due to spoilage. The odors associated with this wide range of sources are complex and can consist of a mixture of different substances including, but not limited to, inorganic bases such as ammonia, organic acids such as butyric acid and neutral organic molecules such as allicin (odor of garlic).

25 Many compositions and methods have been developed for the purpose of eliminating or controlling odor. However, these methods and compositions have had only limited success because the agents typically used for such purposes either are effective at controlling only a limited range of odors, or control odors by masking them with other odors (fragrances) or have other limitations.

30 For example, one conventional method of masking such odors often involves the use of fragrances or perfumes. However, masking has disadvantages. Masking

does not remove the components of the odors itself, and for many, the masking odor itself is unpleasant. In addition, many odor reducing or masking agents are specific and not effective for controlling all odors. Specifically, amine and ammonia odors are difficult to mask with fragrances.

- 5 Sorbants like activated carbon and natural and synthetic zeolites are effective for trapping many odors, but the use of both have disadvantages. For example, activated carbon is unsuitable for use where the sorbant(s) may come in contact with animals, furniture, or carpets, while natural and most synthetic zeolites have low capacities for odors in the presence of moisture. Natural zeolites typically trap odors.
- 10 However, the capacity of natural zeolites is very limited due to natural zeolites stronger affinity for water than for the odor molecules. Natural zeolites are often used to release fragrances on exposure to moisture rather than to trap odors.

- Another method of odor removal is by chemical reaction(s). Chemicals like acids and bases can be used to trap the base and acid components present that cause
- 15 odors. Acids like butyric acid and hydrogen sulfide can be trapped by bases like sodium bicarbonate (baking soda) while basic compounds like ammonia can be trapped by acids like phosphoric acid. In order to maximize their performance, generally the acid and base components are separated into different traps and the odors are treated sequentially. The use of acids and bases to trap odors is incomplete
- 20 because these sorbants do not trap neutral odors such as allicin. Consequently, the use of acids and bases alone is insufficient.

- In addition to the use of acids and bases for odor removal, metals, metal oxides and metal salts have been used for control of odors by chemical interactions. In this case, transition metals like copper are particularly effective in trapping odors due to
- 25 sulfides by forming non-odorous metal complexes with the sulfides. Again, the metals have limited coverage and are ineffective against neutral molecules and ammonia odors.

- Despite the foregoing, need continues to exist in the art to provide a composition and method for effectively reducing odor that is odorless and effectively
- 30 controls a wide range of odors, including ammonia, amines, sulfur bearing compounds

and other malodorous materials, e.g. fatty acids, which are generated from pet litter, household activities and wastes and the like.

OBJECTS OF THE INVENTION

5 It is an object of the present invention to provide safe and effective novel compositions for reducing a wide range of odors, including ammonia, sulfurous odors and neutral organics, which are non-toxic and safe for direct or indirect human or animal contact.

It is a further object of the invention to provide a method for reducing a wide range of odors using the odor reducing composition(s) of this invention.

10 It is a still further object of the invention to provide odor controlling articles containing the odor reducing compositions of the invention that are effective at controlling odors emitted from the articles during use.

The above and other objects are met in the invention which is described in more non-limiting detail hereinafter.

15 SUMMARY OF THE INVENTION

According to the invention, and in one embodiment, odor reducing compositions are provided comprising at least one acid having a pK_a greater than about 2.9 and less than about 6, water solubility less than about 45 g/100g H_2O , and an oral rat LD_{50} greater than about 2200 mg/kg, at least one synthetic zeolite having at
20 least about 90 percent of its tetrahedral oxide units as SiO_2 tetrahedra, a capacity for adsorbed water of not greater than 10 weight percent when measured at 25 °C and at a water vapor pressure of 4.6 torr, and pore apertures nominally at least 5.5 Å in diameter, from which the original water of hydration has been substantially removed, and at least one substance selected from the group consisting of metal, metal oxide, a
25 metal salt, and any combination thereof.

In another embodiment of this invention, a method for removing odors from an odor emitting environment is provided comprising contacting an effective amount of the odor reducing composition of the invention with the odor emitting environment

and allowing for a sufficient time to pass for the odor reducing composition to essentially remove the odor.

In yet another embodiment of this invention, a method for removing odor is provided comprising adding an effective amount of the odor reducing composition of the invention to an article that, in the absence of the odor reducing composition, emits an odor during use, and essentially removing the emitted odor from the article.

In a still further embodiment of this invention, an article is provided comprising an article that, in the absence of the odor reducing composition of the invention, emits an odor during use, and the odor reducing composition of the invention in an amount effective at controlling odors emitted from the article during use.

DETAILED DESCRIPTION OF THE INVENTION

This invention comprises a novel composition for reducing odor. The composition is safe and effective at reducing a broad array of odors and is practically non-toxic. Further, unlike prior odor reducing compositions, the present composition is safe for direct or indirect animal contact. As used herein the term "animal" includes human beings.

The present inventive composition for reducing odor comprises at least one acid having a pK_a greater than about 2.9 and less than about 6, water solubility less than about 45 g/100g H_2O , and an oral rat LD_{50} greater than about 2200 mg/kg, at least one synthetic zeolite having at least about 90 percent of its tetrahedral oxide units as SiO_2 tetrahedra, a capacity for adsorbed water of not greater than about 10 weight percent when measured at 25 °C and at a water vapor pressure of 4.6 torr, and pore apertures nominally at least about 5.5 Å in diameter, from which the original water of hydration has been substantially removed, and a substance selected from the group consisting of metal, metal oxide, a salt of a metal or metal oxide, and any combination thereof. In the practice of this invention, the composition of this invention is produced by admixing the readily available components together. This is contrary to prior art odor reducing compositions that describe zeolites coated with

metal compounds or serve as a support for metal compounds. Zeolites that are coated with metal compounds, or serve as an inert support for metal compounds, are not suitable for use in the present invention because the metallic coating of zeolites result in at least partial inactivation of the adsorption properties of the zeolite. Accordingly, the zeolite becomes inert, and does not serve an active role in the adsorption of odors as in the present invention.

The invention comprises at least one acid having a pK_a greater than about 2.9 and less than about 6, water solubility less than about 45 g/100g H_2O , and an oral rat LD_{50} greater than about 2200 mg/kg. Preferably, the acid is essentially odorless. In addition, it is currently preferred that the first pK_a (pK_{a1}) of the acid is greater than about 2.9 and less than about 6. In one embodiment, at least one acid is selected from the group consisting of an organic acid, amino acid, and mixtures thereof. Examples of suitable acids useful herein include but are not limited to carboxylic acids, polycarboxylic acids having two or more $-COOH$ groups, amino acids, polyamino acids having two or more $-COOH$ groups, and any suitable combination thereof. Accordingly, the acid may be adipic, polyacrylic, polyaspartic, aspartic, glutamic, mixtures thereof and the like.

Illustrative dicarboxylic acids that may be used in the present invention include, but are not limited to, adipic, aspartic, cyclohexane-1:1-dicarboxylic, cystine, dimethylmalonic, fumaric, sorbic, glutaric, methylsuccinic, itaconic, succinic and tartaric acid, mixtures thereof and the like. Preferred acids useful in this invention include adipic, fumaric, sorbic, aspartic, mixtures of, and the like.

The odor reducing composition(s) of this invention also includes at least one of a metal, metal oxide, a salt of a metal or metal oxide, or any combination thereof. Metal oxides that may be used herein, include but are not limited to, zinc oxide, copper oxide, iron oxide, manganese oxide, tin oxide, silver oxide, mixtures thereof and the like. Preferred metal oxides include zinc oxide, copper oxide and iron oxide, with zinc oxide and copper oxide being most preferred.

In another embodiment, a metal may also be used. Suitable metals according to the invention include, but are not limited to, zinc, copper, iron, manganese, tin and

silver. Preferred metals are zinc, iron and copper, with zinc and copper being most preferred.

If desired, a salt of a metal or metal oxide may also be employed in the odor reducing composition(s) of this invention. Any salt of a suitable metal or metal oxide
5 may be used including, but not limited to, salts of zinc, copper, iron, manganese, tin and silver. Preferred salts are salts of zinc or zinc oxide, iron or iron oxide and copper or copper oxide, with salts of zinc, copper, zinc oxide and copper oxide being more preferred. Salts of copper that may be used include, but are not limited to CuSO_4 . It is generally desired to use environmentally friendly salts including but not limited to
10 metal sulfates, halides, carbonates, bicarbonates, organic acid salts, mixtures thereof and the like. Examples of salts which are effective in the practice of this invention include zinc sulfate, copper sulfate, zinc chloride, copper chloride, zinc aspartate, mixtures thereof and the like. Zinc salts are most preferred.

At least one zeolite/molecular sieve, is used as an active agent in the present
15 invention. Zeolites useful herein include those zeolites and molecular sieves where sufficient sites and/or pores are available for carrying out this invention so as to provide ample means for adsorption, desorption, diffusion and the like. The zeolite of the odor reducing composition of the invention has an effective number of pores or sites available for the practice of this invention. Zeolites, generally, are three-
20 dimensional, microporous, crystalline solids with well defined structures that contain aluminum, silicon and oxygen in their regular framework. Zeolites are minerals that are mined in many parts of the world and also produced synthetically. Prior art odor reducing compositions have used natural zeolites for odor adsorption. However, natural zeolites have a high affinity for water. Therefore, they are unsuitable in the
25 present invention because the odorous compounds are displaced during use. Natural zeolites are essentially inert when used in the present composition, particularly when such compositions are contacted with water during use. The effective zeolites are those zeolites that have an affinity for organic compounds, but a sufficiently low affinity for water such that there is essentially no displacement of organic compounds.

Accordingly, only synthetic zeolites are suitable for the present invention. Therefore, as used herein, the term "zeolite" means synthetic zeolite.

Suitable zeolites useful herein include high-silica zeolites. Examples of high-silica zeolites suitable for the present invention include, but are not limited, to the
5 synthetic high-silica zeolites described in U.S. Patent Nos. 5,013,335 and 4,795,482 to Marcus and Gioffre, et al., which issued on May 7, 1991 and January 3, 1989, respectively, and which are herein incorporated by reference in their entirety.

In a specific embodiment, the zeolite of the present invention is at least partially activated, at least about 90 percent of the framework tetrahedral oxide units
10 are SiO_2 tetrahedra, have pore diameters of at least 5.5 Å and have a capacity for adsorbed water not greater than 10 weight percent when measured at 25° C and at a water vapor pressure of 4.6 torr. In one embodiment, the zeolite is an aluminosilicate having a framework $\text{SiO}_2/\text{Al}_2\text{O}_3$ molar ratio greater than 35. In an alternate
15 embodiment, the activated zeolite is comprised of a mixture of a silica polymorph and an aluminosilicate having a framework $\text{SiO}_2/\text{Al}_2\text{O}_3$ molar ratio in the range of about 200 to about 500. Illustratively, commercially available zeolites suitable for use in the present invention include, Zeolyst™ CBV 901, available from Zeolyst International, Valley Forge, PA, USA; and Smellrite®, available from Universal Oil Products, Des
Plaines, IL, USA.

20 The odor reducing composition of the invention comprises an acid in the range of about 0.1% to about 99.7%, metal, metal oxide or a salt of a metal or metal oxide and any combination thereof, in the range of about 0.1% to about 99.7%, and synthetic zeolite in the range of about 0.1% to about 99.7% of the total composition based on the sum of these three components being 100%. In use, the relative ratios of
25 the active components may be tailored as desired for specific odor reduction applications.

In another embodiment the composition of this invention comprises an acid in the range from about 33 to about 99%; metal, oxide or a salt of a metal oxide and any combination thereof in the range from about 0.5 to about 40% and zeolite from about
30 5% to about 50% based on the sum of three components being 100%.

Preferably, in one other embodiment, the metal, metal oxide, or salt and acid combined are present in the range of about 24% to about 99.7% of the total composition and zeolite comprises in the range of about 0.3% to about 76% of the total composition.

5 In yet another embodiment, metal, metal oxide, or salt and acid combined are present in the range of about 50% to about 98% of the total composition and zeolite comprises about 2% to about 50% of the total composition.

In a specific embodiment of the invention, relating to use in a deodorizing composition, e.g. in a cat litter deodorizer, carpet deodorizer or shoe odor deodorizer,
10 the acid comprises about 85-95% of the total composition, the metal oxide, metal or salt comprises about 0.5 to about 5% of the total composition and the synthetic zeolite comprises about 1% to about 12% of the total composition based on the sum of these three components being 100%.

In a more specific embodiment, the odor reducing composition of the
15 invention comprises about 0.5 to about 2.0% metal, metal oxide, or salt, preferably ZnO, about 9 to about 11% zeolite; and about 88 to about 89.5% acid, preferably aspartic acid or fumaric acid.

In yet another specific embodiment, the odor reducing composition of the
invention comprises about 11% aspartic acid, about 24.5% adipic acid, about 43%
20 ZnO and about 21.5% zeolite.

In still another specific embodiment, the odor reducing composition of the invention comprises about 90-94% acid, preferably aspartic acid or fumaric acid, about 1-3% metal, metal oxide, or salt, preferably ZnO, and about 5-7% zeolite.

In yet another embodiment, an odor reducing composition of the invention
25 includes a diluent. The amount of diluent in the odor reducing composition of the invention is from 0 to about 70%, i.e. the amount of acid, metal, metal oxide, or salt, and zeolite in the odor reducing composition being about 30 to 100%. Any convenient and compatible diluent, that is generally inert, may be used, including but not limited to sodium sulfate, sodium chloride, sodium bicarbonate, sodium
30 carbonate, clay, sepiolite, palygorskite, activated carbon, activated carbon filter,

activated alumina, sepiolite-admixed paper, silica gel, activated clay, vermiculite, diatomaceous earth, pulp, fibers, cloth, polymeric porous body, and a natural zeolite, e.g. a natural, inorganic zeolite such as clinoptilolite. The diluent may be selected based on the undesired odor or application.

5 In a specific embodiment where a diluent is used, the odor reducing composition of the invention comprises about 30-38% aspartic acid or fumaric acid, about 0.5-1% ZnO, about 1-2% zeolite, and about 60-67% clinoptilolite.

 In addition, in an embodiment of the invention for reducing odor, the composition optionally may contain other components if desired, including, but not
10 limited to, biocides, chelants and absorbents, mixtures thereof and the like. Other components that may be optionally incorporated usefully into a composition of this invention for reducing odor are selected in accordance with specific applications of the invention after reading this specification.

 In some instances, it may be desirable to combine the above described
15 composition for reducing odor directly with a substance that, in the absence of the odor reducing composition, emits an odor during use. As used herein, the term "odor emitting" means to diffuse or contain a pleasant or unpleasant scent that stimulates the olfactory organ. Accordingly, as used herein, an odor emitting substance is any substance capable of stimulating the olfactory organ, whether offensive or non-
20 offensive. Further, an odor emitting environment is an environment capable of stimulating the olfactory organ, whether offensive or non-offensive non-limiting. Examples of non-offensive odors include perfume and sweet smells non-limiting. Examples of offensive odors include ammonia and sulfurous odors.

 The odor reducing composition of the invention may be used alone or may be
25 used in combination with other materials or articles to remove odor. The odor reducing composition of the invention is simply admixed with the materials or articles to remove the odor emitting substances. For example, the odor reducing composition of the invention may be incorporated into personal care articles like foot powders, pads, laundry preparations, pet litters and cleaning products. The composition of the
30 invention may also be used with deodorizers, such as carpet deodorizers and vehicle

deodorizers. Often, deodorizers work by masking odors with perfumes and other odors. Prior art odor reducing substances have failed to produce a composition that effectively adsorbs odor without the use of perfuming masks, which are offensive to many. While some in the past may have succeeded to produce compositions that

5 adsorb certain odors, no prior art composition or method has been proven to effectively adsorb the broad spectrum of odors effectively adsorbed by the present invention. For example, any commercially available pet litter may be admixed with an effective amount of the composition of the present invention to adsorb any

10 masking odors that may be irritating or offensive. Also, a commercially available odor controlling substance like carpet deodorizer, may be combined with the present composition to increase the overall effectiveness of its odor adsorption. Accordingly, less of the commercially available odor controlling substances is necessary for effective odor control, making the incorporation of the odor reducing composition of the invention cost effective.

15 The concentration of the odor reducing composition of the invention is largely dependent upon the specific application of this invention and would be readily apparent to one of ordinary skill in the art. In one embodiment of the invention, the odor reducing composition of the invention is admixed with pet litter to reduce any emitted odor or to improve the odor reducing capabilities of the litter itself. The odor

20 reducing composition of the invention is added to the used or unused pet litter in an amount effective to reduce any undesired odors emitted from the litter thereby producing an odor-controlled pet litter. Any effective amount of the odor reducing composition of the invention may be added to used or unused pet litter or other articles, which in the absence of the present invention emits an odor.

25 In one embodiment, the odor-controlled pet litter comprises in the range of about 0.1% to about 20% of the odor reducing composition of the invention.

In a preferred embodiment, the odor-controlled pet litter comprises in the range of about 0.1% to about 10% of the odor reducing composition of the invention.

In a more preferred embodiment, the odor-controlled pet litter comprises in the

30 range of about 1% to about 5% of the odor reducing composition of the invention.

In yet another embodiment of this invention, the odor reducing composition of the invention is optionally admixed with one or more effective deodorizers to reduce odors emitted from the deodorizer or to increase the odor reducing capabilities of the deodorizer itself. Where the odor reducing composition of the invention comprises deodorizers or is used in some useful combination with one or more deodorizers.

In another embodiment comprising cat litter deodorizer, carpet and or shoe deodorizer, the invention comprises about 88 to about 89.5% acid, about 9 to about 11% zeolite and about 0.5 to about 2% metal oxide based on the sum of these components being 100%.

In some instances, it may be impractical to directly combine the present compositions with substances that, in the absence of the present invention, emit odor. For example, many personal care articles like menstrual pads and diapers cannot be effectively admixed with the present composition. Therefore, and in one embodiment of the invention, the odor reducing composition of the invention may be simply placed in contact with or incorporated within articles, which in the absence of the odor reducing composition of the invention emit odor during use, to thereby produce odor-controlled articles. The odor reducing composition of the invention may be placed in contact with or incorporated into any article to remove the odor produced during use of that article. For example, the odor reducing composition of the invention may be placed in contact with or incorporated into pads, including diapers, adult incontinence products, and menstrual pads, tissue, lagoons, bandages, dressings, surgical sponges, personal care articles, cleaning products, food tray liners, room and vehicle, e.g. auto, truck, air transport and trains, deodorizers like solid air fresheners, bedding, garbage bags, clothing, shoes and carpet. The present composition may be incorporated within the above articles in any conventional and effective manner known to those of skill in the art.

A method for reducing odor using the above odor reducing composition(s) is also provided according to the present invention. The method for reducing odor includes contacting an effective amount of an odor reducing composition of the invention with at least one article, which, in the absence of the odor reducing

composition of the invention, emits an odor during use, and removing the emitted odor from the article. Further, according to the invention, any article that emits odor in the absence of the odor reducing composition of the invention is suitable herein.

Unlike prior art odor control compositions, the present composition effectively

5 removes a wide variety of odors including ammonia and sulfurous odors. Without being bound by theory it is believed that the mechanism of odor removal of this invention includes physical and chemical sorption. In an embodiment, the composition of the present invention is admixed with or placed in contact with pads, lagoons, tanks, animal waste, bandages, dressings, surgical sponges, catamenial
10 devices, beef, poultry, and fish tray liners, personal care articles, foot powders, laundry preparations, pet litters such as cat litter and dog litter, cleaning products, deodorizers, bedding, floors, garbage cans, diaper pails, refrigerators, carpet and any substance that emits odor in the absence of the odor reducing composition of the invention. The composition then removes the emitted odor.

15 In another embodiment, an effective amount of the odor reducing composition of the invention is placed in contact with an odor emitting environment and a sufficient amount of time is allowed to pass for the odor reducing composition to essentially and effectively remove the odor.

In one specific embodiment, the composition of the present invention is
20 enclosed in an article that allows for movement and containment of the composition of this invention. The article may be placed in an odor emitting environment where odor control is desired. For example, the present composition may be placed in a box, bound in a cloth, or bag and placed in a closet, bathroom, or drawer or the like to control odor. The only restriction is that the article which encloses or contains a
25 composition of this invention be sufficiently porous for the odor reducing composition to remove any undesired odor.

An effective amount of the odor reducing composition of the present invention is used in the method for reducing odor of the invention. An effective amount is the amount necessary for the odor reducing composition of the invention present to
30 effectively remove an emitted odor from an odor emitting article or environment.

Accordingly, the effective amount used in the present method varies depending on the specific odors emitted, as well as the environment of use among other factors.

However, the effective amount of the odor reducing composition of the invention necessary for removing an odor would be readily apparent to one skilled in the art

5 without undue experimentation after reading this specification.

All references cited herein are hereby incorporated by reference for their relevant teachings. Accordingly, any reference cited herein and not specifically incorporated by reference is, nevertheless, incorporated by reference in its entirety as if part of the present specification.

10

EXAMPLES

The following examples illustrate specific embodiments of the invention without limiting the scope of the invention in any way.

In the examples which follow, aspartic acid was acquired from Solutia Inc., 385 Marshall Avenue, St. Louis, MO 63119, CBV 901 zeolite catalyst was acquired
15 from Zeolyst International at Valley Forge, PA; Smellrite® was acquired from Universal Oil Products, 307 Fellowship Road, Mount Laurel, IL.

Unless otherwise specified, use of "%" is on a weight basis.

EXAMPLE 1

Two samples (Samples 1-2) of an odor reducing composition of the invention
20 and a comparative sample were prepared by adding the following to three individual jars, stirring the contents of the jars, capping the jar and shaking the jars.

25	Sample-1	100 g zinc oxide; 100 g L-aspartic; and 100 g zeolite (CBV 901).
	Sample-2	100 g zinc oxide; 100 g L-aspartic; and 100 g Smellrite®.
30	*Sample-3	100 g zinc oxide; 100 g L-aspartic; and 100 g zeolite (UOP PA 451).

* comparative sample

These two samples (Samples 1-2) were then tested against comparative samples of unused Arm & Hammer® cat litter deodorizer and Sample-3 by placing
 5 three teaspoons of each of the samples and the unused Arm & Hammer® cat litter deodorizer in a jar containing used pet litter. The results demonstrate that samples containing Smellrite® or Zeolyst™ CBV 901 are preferred over samples containing PA 451. The results are summarized in Table 1 below.

Table 1

Sample Composition	Amount added to pet litter	Efficacy
Sample-1	3 teaspoons	No odor
Sample-2	3 teaspoons	No odor
Sample-3*	3 teaspoons	Odor
Arm & Hammer® cat litter deodorizer*	3 teaspoons	Masks odor with fragrance effectively
1/3 Sample-1 + 2/3 Sample-3	3 teaspoons	weak odor
1/3 Sample-2 + 2/3 Sample-3	3 teaspoons	very weak odor

10

*comparative sample

The results also indicate that compositions of this invention utilizing Smellrite® and Zeolyst™ CBV 901 were demonstrated to be very effective in removing odors caused by solid cat litter, while zeolite UOP PA 451 (a comparative
 15 composition) was less effective.

EXAMPLE 2

ODOR CONTROL TESTING OF AMMONIA

20

The following (odor reducing) compositions illustrative of this invention were prepared for odor control testing. Specifically, the ability to remove ammonia was tested for various odor reducing compositions. Samples were prepared by following the method of Example 1. 29.5% NH₄OH was added to each of the following odor

reducing compositions. 2 or 3 drops of 29.5% NH_4OH (10 drops = 0.28 g) were added to about 10 g of the odor reducing compositions in a 2 oz. jar. The 29.5% NH_4OH and the odor reducing compositions were admixed and allowed to set for about 10 minutes with the lid tightly closed. If there was no odor upon removal of the lid, as determined by smell, additional 29.5% NH_4OH was added and the test was repeated. As used herein, the grams of 29.5% NH_4OH adsorbed represents the maximum amount of 29.5% NH_4OH removed by 10 grams of the respective samples. Accordingly, at any concentration level above the amounts indicated, an ammonia odor was emitted from the mixture. The results are summarized in Tables 2 and 3.

The above results and those in Tables 2 and 3 below indicate that both L-aspartic and adipic acid are demonstrated to be very effective in removing odors caused by ammonia.

Table 2

Odor Reducing Composition Number	L-aspartic acid	zinc oxide	Zeolyst™ CBV 901	Advera® 401	13X powder (diluent zeolite)	Grams of 29.5% NH_4OH ** in a 10g sample
1	33 g	33 g	33 g			0.76 g
2	33 g	33 g	3 g	30 g		1.12 g
3	33 g	33 g	3 g		30 g	0.50 g
4	33 g	33 g	11 g	22 g		1.96 g
5	33 g	33 g	11 g		22 g	0.36 g
6	33 g	33 g	6 g	27 g		1.54 g
7	33 g	33 g	6 g		27 g	0.45 g
8	40 g	40 g	20 g			1.90 g
9	33 g	44 g	22			2.10 g
*10	50 g	50 g				1.48 g

*comparative sample

**amount of 29.5% NH_4OH added before persistent odor of ammonia is detectable

Table 3

Odor Reducing Composition Number	Adipic acid	Zinc Oxide	Zeolyst™ CBV 901	Advera® 401	13X powder (diluent zeolite)	Grams of 29.5% NH ₄ OH** in a 10g sample
1	33 g	33 g	33 g			2.10 g
2	33 g	33 g	3 g	30 g		1.68 g
3	33 g	33 g	3 g		30 g	0.56 g
4	33 g	33 g	11 g	22 g		2.10 g
5	33 g	33 g	11 g		22 g	0.42 g
6	33 g	33 g	6 g	27 g		2.10 g
7	33 g	33 g	6 g		27 g	0.70 g
8	40 g	40 g	20 g			2.24 g
9	33 g	44 g	22 g			2.24 g
*10	50 g	50 g				2.10 g

*comparative sample

**Amount of 29.5% NH₄OH added before persistent odor of ammonia is detectable.

5

EXAMPLE 3

ODOR CONTROL TESTING OF AMMONIA USING ODOR REDUCING COMPOSITIONS OF THE PRESENT INVENTION

3.3 g of each acid indicated in Table 8 (below) were admixed with 3.3 g zinc oxide, available from Fisher Scientific and 3.3 g Advera® 401 (PQ Corporation) to form an odor reducing composition in accordance with the present invention. About 10 g of the respective odor reducing compositions were placed into individual 2 oz. jars. 29.5 % NH₄OH was added to the odor reducing compositions, capped and allowed to set for 10 minutes. If there was no odor, detected qualitatively after ten minutes elapsed, more 29.5% NH₄OH was added and the test was repeated until an odor was emitted. The results of this Example are summarized in Table 4 below and demonstrate that odors caused by ammonia can be removed by the action of odor reducing compositions of the inventions that include these acids.

Table 4

Acid used in the odor reducing composition	Drops/grams 29.5% NH ₄ OH**
*Ascorbic acid	70 = 1.96 g
*Citric acid	70 = 1.96 g
Fumaric acid	120 = 3.36 g
Glutaric acid	85 = 2.38 g
Methyl Succinic acid	90 = 2.52 g
*Malic acid	40 = 1.12 g
o-Phthalic acid	85 = 2.38 g
Succinic acid	90 = 2.52 g
tartaric acid	90 = 2.52 g

*comparative samples

**Amount of 29.5% NH₄OH added before persistent odor of ammonia is detectable.

5

EXAMPLE 4

COMPARATIVE ODOR CONTROL TESTING OF AMMONIA USING ODOR
REDUCING COMPOSITIONS OF THE PRESENT INVENTION AND
10 COMMERCIALY AVAILABLE ZEOLITES ALONE

Samples were prepared following the procedure of Example 1 above. 29.5%
NH₄OH was added dropwise (10 drops = 0.28 g) to 10 g of each of the odor reducing
compositions, or zeolites shown in Table 5 in a 2 oz jar. Covered with a lid, the jar is
15 shaken and allowed to set for 10 min. If there is no odor, additional 29.5% NH₄OH is
added and the test is repeated until odor is emitted. The results of this Example are
summarized in Table 5.

Table 5

Odor Reducing Composition / Zeolite	Grams of 29.5% NH ₄ OH**
33.4% L-aspartic acid 33.3% zinc oxide 33.3% Zeolyst™ CBV 901	1.54 g
30% Fumaric acid 10% Sorbic acid 30% Zinc Sulfate 30% Smellrite®	3.22 g
20% L-aspartic acid 20% Fumaric acid 20% Zinc Oxide 30% Advera® 401 10% Smellrite®	2.24 g
20% L-aspartic acid 20% Fumaric acid 5% Zinc Sulfate 15% Copper Sulfate 30% Advera® 401 10% Smellrite®	1.68 g
* Zeolyst™ CBV 901	0.14 g
* Smellrite®	0.56 g

* control sample

** Amount of 29.5% NH₄OH added before persistent odor of ammonia is detectable.

5

The results of this Example show the ability of the odor control compositions in accordance with the present invention to remove significantly more ammonia than the use of zeolites alone.

EXAMPLE 5

10

COMPARATIVE ODOR CONTROL TESTING OF AMMONIA USING ODOR REDUCING COMPOSITIONS OF THE PRESENT INVENTION AND OTHER COMMERCIALY AVAILABLE ODOR CONTROL COMPOSITIONS

15

10 g of each of the odor control compositions listed below were placed into a 2 oz jar. 29.5% NH₄OH, from Fisher Scientific, was added to each jar, the jar was shaken and allowed to set for about 10 min. The odor was monitored. If there was no odor after ten minutes had elapsed, more 29.5% NH₄OH was added and the test repeated. The results of this Example are summarized in Table 6.

Table 6

Odor Control Composition	29.5% NH ₄ OH**
*Tidy Cat® Scoop (Ralston Purina Company)	0.06 g
*Super Scoop™ (Arm & Hammer®)	0.28 g
*Ammo Cat® (Aquarium Pharm.)	0.28 g
*Pearl Fresh (PETsMART)	0.56 g
*Odor Pro (Odor Pro)	0.28 g
*Odor Sentry (Ammonia Hold)	0.14 g
*Odor Out (No Stink)	0.28 g
*Tidy Cat® cat box deodorizer (Ralston Purina Company)	Very Strong Odor <0.14 g
*Cat litter deodorizer (Arm & Hammer®)	Strong odor <0.14 g
60% L-aspartic; 10% Smellrite®; and 30% zinc oxide.	1.54 g

*comparative example

**Amount of 29.5% NH₄OH added before persistent odor of ammonia is detectable.

- 5 The results of this Example indicate that the compositions for reducing odor of the present invention remove substantially more ammonia odor than other commercially available odor control compositions.

EXAMPLE 6

10 COMPOSITION FOR REDUCING ODOR OF THE PRESENT INVENTION USED IN COMBINATION WITH PET LITTER

- 15 60 g aspartic acid, 10 g Smellrite® and 30 g zinc oxide were admixed to produce a composition for reducing odor in accordance with the present invention. A comparative sample of Tidy Cat® scoop, commercially available from Ralston Purina Company, St. Louis, MO, was combined with the composition in a 2 oz. jar at the amounts indicated in the Table 7 below to form four distinct odor reducing compositions in accordance with the present invention. 29.5% NH₄OH, available from
- 20 Fisher Scientific, was added to each of the final compositions dropwise until an ammonia odor was emitted. If no odor was emitted additional 29.5% NH₄OH was

added and the test was repeated until an odor was emitted. The results of this Example are summarized in Table 7.

Table 7

Tidy Cat® scoop	Odor Reducing Composition of the Present Invention	29.5% NH ₄ OH**
10 g*	0 g	0.08 g
9 g	1 g	0.42 g
8 g	2 g	0.84 g
7 g	3 g	0.98 g
0	10 g	1.54 g

*control sample

5 ** Amount of 29.5% NH₄OH added before persistent odor of ammonia is detectable.

The results of this Example indicate that the odor reducing composition of the present invention adsorbed substantially more ammonia odor than Tidy Cat® Scoop alone. The results also indicated that the odor reducing compositions formed by the addition of the composition of the present invention to other pet litters resulted in enhanced adsorption capabilities as compared to the use of the pet litter alone.

EXAMPLE 7

COMPARATIVE ODOR CONTROL TESTING OF SULFIDE

15 A 0.2% aqueous sulfide solution was prepared by mixing sodium sulfide, acetic acid and water. An odor reducing composition of the present invention was prepared by mixing 60 g L-aspartic acid, 10 g Smellrite® and 30 g zinc oxide. 0.1 gram of the above odor reducing composition was placed in a 2 oz jar and a lid was placed on the jar. One gram of the other commercially available odor control compositions were placed in individual 2 oz. jars. The sulfide solution was added to each of the jars dropwise and admixed with the respective compositions. If no sulfide was detected after approximately 10 minutes, additional sodium sulfide was added and the test was repeated until sulfide was detected. The results are summarized in

20 Table 8 below.

25

Table 8

Sample	Drops of 0.2% sodium sulfide solution
Odor Reducing Composition	140-250
*Tidy Cat® scoop (Ralston Purina)	3
*Super Scoop™ (Arm & Hammer)	2
* Ammo Cat® (Aquarium Pharmaceuticals, Inc., Chalfont, PA)	1
*ExquisiCat® Pearl Fresh cat litter(PETsMART, Inc. Phoenix, AZ)	2
*Odor Pro (Odor Pro®)	2
*Odor Sentry™ pet odor eliminator (Ammonia Hold, Inc.®, Little Rock, AR)	2
*Odorz Out (No Stink)	8
*Tidy Cat box deodorizer (Ralston Purina)	1
*Cat Litter deodorizer (Arm & Hammer)	1

*comparative examples

This Example shows that the odor reducing formulation is at least 15 times as effective as commercially available products available for the removal of sulfide odors.

EXAMPLE 8

EFFECT OF ZINC CONCENTRATION

10

A 0.2% aqueous sulfide solution was prepared by combining sodium sulfide, acetic acid and water. Compositions for reducing odor were prepared in accordance with the present invention by mixing L-aspartic acid, zinc oxide, Smellrite® and CBV 901 in the proportions indicated below in Table 9. 0.1 g of the resulting compositions were each placed in a jar. The sulfide solution was added dropwise to each of the jars until an odor was emitted. If no odor was emitted after approximately ten minutes, additional sulfide solution was added, and the test was repeated until an odor was emitted. Separately, in different containers, 29.5% NH₄OH was added to each 10g sample until and odor of ammonia was detected. The results of this Example are summarized in Table 9 below.

15

20

Table 9

% L- aspartic	% zinc Oxide	% Smellrite®	% Zeolyst™ CBV 901	Drops Sulfide Solution	Drops 29.5% NH ₄ OH**
60	2	10	28	15	95
60	5	10	25	25	90
60	10	10	20	60	80
60	20	10	10	125	65
60	30	10	0	225	55

**Amount of 29.5% NH₄OH added before persistent odor of ammonia is detectable.

The results demonstrate that these formulations are effective in controlling both ammonia and sulfide odors over a broad range of zeolite and metal oxide concentrations.

EXAMPLE 9

ODOR CONTROL TESTING OF SULFUR USING COMPOSITIONS FOR REDUCING ODOR COMPRISING LOW CONCENTRATIONS OF METAL OXIDE

Zinc oxide, Smellrite® and L-aspartic acid were admixed to form a composition for reducing odor in accordance with the invention having the following approximate composition: 0.5% zinc oxide, 10% Smellrite® and 89.5% L-aspartic. Lead acetate strips were used to detect the presence of sulfide after 10 minutes. A 0.2% aqueous sulfide solution was prepared by mixing sodium sulfide and acetic acid in water. The sulfide solution was added dropwise to 1 g of the composition. If an odor was not emitted, additional sulfide solution was added until odor was emitted. 14 drops of sulfide solution was added before an odor was emitted.

Zinc oxide, Smellrite® and L-aspartic acid were admixed to form a composition for reducing odor in accordance with the invention having the following approximate composition: 0.5% zinc oxide, 10% Smellrite®, 59.5% Clinoptilolite and

30% L-aspartic acid were admixed to form a composition for reducing odor in accordance with the invention. A 0.2% aqueous sulfide solution was prepared by mixing sodium sulfide, acetic acid and water. The sulfide solution was added dropwise to 1 g of the composition. If an odor was not emitted, additional sulfide
5 solution was added until an odor was emitted. 10 drops of sulfide solution was added before an odor was emitted.

Zinc oxide, Smellrite® and L-aspartic acid were admixed to form a composition for reducing odor in accordance with the invention having the following approximate composition: 1.0% zinc oxide, 10% Smellrite® and 89% L-aspartic
10 acid. A 0.2% aqueous sulfide solution was prepared by mixing sodium sulfide, acetic acid and water. The sulfide solution was added dropwise to 1 g of the composition until an odor was emitted. 24 drops of sulfide solution was adsorbed before an odor was emitted.

Zinc oxide, Smellrite® and L-aspartic acid were admixed to form a
15 composition for reducing odor in accordance with the invention having the following approximate composition: 2.0% zinc oxide, 10% Smellrite® and 88% L-aspartic were admixed to form a composition for reducing odor in accordance with the invention. A 0.2% aqueous sulfide solution was prepared by mixing sodium sulfide, acetic acid and water. The sulfide solution was added dropwise to 1 g of the
20 composition until an odor is emitted. 140 drops of sulfide solution was adsorbed before an odor was emitted.

These results indicate the preferred range of zinc oxide in an odor reducing composition of this invention for use in an application where sulfurous odors are emitted.

25 EXAMPLE 10 – COMPARATIVE

ODOR CONTROL TESTING OF B-CYCLODEXTRIN HYDRATE AND FEBREZE®

0.5 g B-cyclodextrin hydrate was placed in a 2 oz jar with 2 drops of 0.2%
30 aqueous sulfide solution and a lead acetate strip. The lead acetate strip turned black indicating sulfide present in the air.

5.0 g of B-cyclodextrin hydrate was placed in a 2 oz jar with 2 drops of 29.5% NH_4OH . A strong odor of ammonia was emitted.

1.0 g of liquid Febreze® (Proctor & Gamble) was placed in a 2 oz jar with 1 drop of a 0.2% aqueous sulfide solution and a lead acetate strip. The lead acetate strip
5 turned black.

10.0 g of liquid Febreze® was placed in a 2 oz jar with 5 drops of 29.5% NH_4OH . A strong odor was detected.

The results of this example demonstrate that neither B-cyclodextrin hydrate nor Febreze® effectively remove ammonia or sulfide odors.

10

EXAMPLE 11 – COMPARATIVE

CAT LITTER ODOR CONTROL

10 g of each of the samples listed Table 11 below were placed in individual
15 2 oz. jars. 29.5% NH_4OH was added dropwise to the jar and admixed until an odor was emitted.

1 g of each of the samples listed in the Table 11 were placed in individual 2 oz. jars. A 0.2% aqueous sulfide solution was added dropwise to each of the samples until an odor was detected. The results are summarized in Table 11 below.

Table 11

Samples	Drops Ammonia adsorbed	Drops Sulfur adsorbed
*Arm & Hammer® Carpet & Room Deodorizer	< 10 drops	< 3 drops
*Arm & Hammer® Cat Litter Deodorizer	< 10 drops	< 3 drops
*Simple Solution Carpet & Room Deodorizer	< 10 drops	< 3 drops
*Glade Pet Odors Carpet & Room Deodorizer	< 10 drops	< 3 drops
*Stop Litter Odor	< 10 drops	< 3 drops
*Pet Clear All Natural	< 10 drops	< 3 drops
*Captain Cat® Cat Litter Deodorizer	< 10 drops	< 3 drops

*comparative example

The results indicate that the odor reducing composition of the invention is more effective at removing both ammonia and sulfide odors than these commercially available compositions for odor reduction.

EXAMPLE 12

The effectiveness of odor reducing compositions of the invention in controlling the odors of 3-methylindole, sodium methoxide, methylsalicylate, triethylamine, isovaleric acid, and dimethylsulfide was compared against the effectiveness of the individual components of the compositions and baking soda, i.e. sodium bicarbonate.

Two odor reducing compositions of the invention were tested. The first odor reducing composition of the invention was 89% L-aspartic acid, 1% ZnO, and 10% Smellrite® zeolite (Invention #1). The second odor reducing composition of the invention was 88% L-aspartic acid, 2% ZnO, and 10% Smellrite® zeolite (Invention

#2). The odor emitting compounds were tested neat, and triethylamine (0.1%), dimethylsulfide (0.1%), and isovaleric acid (0.82%) were also tested as solutions in water. All odor emitting compounds except methylsalicylate were obtained from Aldrich Chemical Company. Methylsalicylate was obtained from Sigma Chemical Company.

The amount of neat odor emitting compounds added to each serum bottle is given in Table 12. In the tests using the water solutions of the odor emitting compounds, 500 μ L of the solutions were used for all samples.

Table 12

Sample	3-methyl-indole (mg)	Sodium meth-oxide (mg)	Methyl-salicylate (mg)	Triethyl-amine (mg)	Isovaleric acid (mg)	Dimethyl-sulfide (mg)
Control – as is	18	22	23	22	23	17
Invention #1	20	29	25	19	22	28
Smellrite	21	21	26	20	21	22
L-aspartic acid	22	19	25	24	23	28
Zinc oxide	35	21	28	25	21	21
Baking soda	30	19	19	19	21	19

The amount of the samples used in the tests were as follows: Invention #1 (1.0g), Invention #2 (1.0g), Smellrite® (0.1 g), L-aspartic acid (0.89g for Invention #1 and 0.88g for Invention #2), zinc oxide (0.01g for Invention #1 and 0.02g for Invention #2), and baking soda (1.0 g).

Samples were prepared using 20 mL serum bottles with septum caps, and gas tight syringes were used to sample the headspace in the serum bottles. The sample was weighed into the serum bottle, the odor emitting compounds were added, and the sample bottles capped. The sample and the odor emitting compound in the serum bottle was mixed in each case. The serum bottle was then allowed to stand for 30

minutes and a 100 µL sample was taken from headspace of the serum bottle using a gas tight syringe and then injected into a gas chromatograph (GC) for analysis.

The GC analysis was performed using a H-P 5890-II GC with a FID detector and a Split/Splitless injector, and a H-P 3396 integrator. The column used was a capillary H-P Ultra-2 (50m x 0.32mm x 0.52µm). The GC conditions used were: injector temperature = 300°C, detector temperature = 330°C, oven temperature program = 70°C initial hold for 4 min., raise temperature 7°C/min. to 235°C, hold at 235°C for 4 min. with total run length of 31.6 min. The split was turned off at injection and turned on after 30 seconds.

The GC results are presented in Tables 13 and 15 (area counts in headspace) and Tables 14 and 16 (% Odor). % Odor was expressed as % of control ("as-is") and calculated as follows: (area sample/area control) x 100. Complete removal of odor is represented as 0% and the control is 100%.

Table 13
GC Analysis – Area Counts in Headspace

Sample	3-methyl-indole	Sodium meth-oxide	Methyl-salicylate	Triethyl-amine	Isovaleric Acid	Dimethyl-sulfide
Control – as is	4000	20378	38790	8590381	53990	10670136
Invention #1	0	0	2049	7591005	20048	8803891
Smellrite	1226	0	15397	5754746	46745	14319488
L-aspartic acid	3580	19129	33871	6236176	47685	4056472
Zinc oxide	2706	38097	32463	7113763	48121	7087306
Baking soda	2669	16261	38721	3019376	2594	12928528

Table 14
% Odor

Sample	3-methyl-indole	Sodium meth-oxide	Methyl-salicylate	Triethyl-amine	Isovaleric Acid	Dimethyl-sulfide
Control – as is	100%	100%	100%	100%	100%	100%
Invention #1	0%	0%	5.3%	88.4%	37.1%	82.5%
Smellrite	30.7%	0%	39.7%	67.%	86.6%	134.2%
L-aspartic acid	89.5%	93.9%	87.3%	72.6%	88.3%	38.%
Zinc oxide	67.7%	187.%	83.7%	82.8%	89.1%	66.4%
Baking soda	66.7%	79.8%	99.8%	35.2%	4.8%	121.2%

5

Table 15
GC Analysis – Area Counts in Headspace

Sample	Triethylamine (0.1% in water)	Isovaleric acid (0.82% in water)	Dimethylsulfide (0.1% in water)
Control – as is	23500	3655	153633
Invention #2	0	485	2459
Smellrite	0	0	1426
L-aspartic acid	0	509	126284
Zinc oxide	18640	0	148158
Baking soda	4473	319	143740

Table 16
% Odor

Sample	Triethylamine (0.1% in water)	Isovaleric acid (0.82% in water)	Dimethylsulfide (0.1% in water)
Control – as is	100%	100%	100%
Invention #2	0%	13.3%	1.6%
Smellrite	0%	0%	0.9%
L-aspartic acid	0%	13.9%	82.2%
Zinc oxide	79.3%	0%	96.4%
Baking soda	19.%	8.7%	93.6%

5 The results demonstrate that the odor reducing compositions of the invention (Invention #1 and Invention #2) reduced the amount of odor for each odor emitting compound compared to the control samples. In addition, the Invention #1 sample demonstrated improved performance over the performance of the individual components for odor emitting compounds 3-methylindole, methylsalicylate, and
10 isovaleric acid. The Invention #1 sample also demonstrated equivalent overall effectiveness to Smellrite® zeolite for sodium methoxide. It is believed that the neat samples of triethylamine and dimethylsulfide were used at too high a loading, i.e. the amount of odor causing material greatly exceeded the capacity of the odor reducing materials being tested.

15 Therefore, the data clearly demonstrate that the odor reducing compositions of the invention are effective for a wide range of odor emitting compounds.

 The present invention has been described in what is considered to represent its preferred embodiments. However, it should be noted that the invention may be practiced otherwise than as specifically illustrated and described without departing
20 from the spirit and the scope of the invention.

WHAT IS CLAIMED IS:

1. A composition for reducing odor comprising:
 - (a) at least one acid having a pK_a greater than about 2.9 and less than about 6, water solubility less than about 45 g/100g H_2O , and an oral rat LD_{50} greater than about 2200 mg/kg;
 - (b) at least one synthetic zeolite having at least about 90 percent SiO_2 tetrahedra oxide units, a capacity for adsorbed water of not greater than about 10 weight percent when measured at 25 °C and water vapor pressure at 4.6 torr, and pore apertures at least about 5.5 Å in diameter, wherein the original water of hydration has been substantially removed; and
 - (c) a substance selected from the group consisting of a metal, metal oxide, a salt of a metal or metal oxide, and any combination thereof.
2. The composition of claim 1 wherein said acid is at least one acid selected from the group consisting of an organic acid, amino acid and any combination thereof.
3. The composition of claim 1 wherein said metal oxide is selected from the group consisting of zinc oxide, copper oxide, iron oxide, manganese oxide, tin oxide and silver oxide.
4. The composition of claim 1 wherein said metal is selected from the group consisting of zinc, copper, iron, manganese, tin and silver.
5. The composition of claim 1 wherein said salt is selected from the group consisting of a salt of zinc, copper, iron, manganese, tin and silver.

6. The composition of claim 1 further comprising an article or substance that, in the absence of said composition for reducing odor, emits an odor during use.
7. The composition of claim 6 wherein said article or substance is at least one selected from the group consisting of personal care articles, foot powders, laundry
5 preparations, pet litters, cleaning products and deodorizers.
8. The composition of claim 1 having about (i) 33 to about 99% acid, (ii) about 0.5 to about 40% metal, metal oxide or salt of a metal or metal oxide, and (iii) about 5 to about 50% synthetic zeolite, wherein the sum of (i), (ii) and (iii) is 100%.
9. The composition of claim 8 having about 88 to about 89.5% acid, about 0.5 to
10 about 2% metal, metal oxide or salt of a metal or metal oxide and about 9 to about 11% synthetic zeolite.
10. The composition of claim 8 having about 90 to about 94% acid, about 1 to about 3% metal, metal oxide or salt of a metal or metal oxide and about 5 to about 7% synthetic zeolite.
- 15 11. The composition of claim 1 wherein said acid and said metal oxide, metal, or salt of metal or metal oxide combined comprise in the range of about 24% to about 99.7% of the total composition and said zeolite comprises in the range of about 0.3% to about 76% of the total composition.
12. The composition of claim 11 wherein said acid and said metal oxide, metal, or
20 salt of metal or metal oxide combined comprise in the range of about 50% to about 98% of the total composition and said zeolite comprises in the range of about 2% to about 50% of the total composition.
13. The composition of claim 1 further comprising a diluent.

14. The composition of claim 13 wherein said diluent is sodium bicarbonate or a natural zeolite.
15. The composition of claim 14 wherein said diluent is clinoptilolite.
16. The composition of claim 15 having about 30-38% aspartic acid or fumaric acid, about 0.5-1% ZnO, about 1-2% zeolite, and about 60-67% clinoptilolite.
17. A composition for reducing odor comprising:
- (a) at least one acid selected from aspartic, fumaric, sorbic, tartaric or adipic acid and
 - (b) at least one synthetic zeolite having at least about 90 percent SiO_2 tetrahedra oxide units, a capacity for adsorbed water of not greater than about 10 weight percent when measured at 25 °C and at a water vapor pressure at 4.6 torr, and pore apertures at least about 5.5 Å in diameter, wherein the original water of hydration has been substantially removed; and
 - (c) zinc oxide or zinc sulfate.
18. An odor-controlled article comprising:
an effective amount of an odor reducing composition, wherein said odor reducing composition comprises (a) at least one acid having a pK_a greater than about 2.9 and less than about 6, water solubility less than about 45 g/100g H_2O , and an oral rat LD_{50} greater than about 2200 mg/kg, (b) at least one synthetic zeolite having at least about 90 percent of its tetrahedral oxide units as SiO_2 tetrahedra, a capacity for adsorbed water of not greater than 10 weight percent when measured at 25° C and at a water vapor pressure of 4.6 torr, and

- pore apertures at least 5.5 Å in diameter, from which the original water of hydration has been substantially removed, and (c) at least one substance selected from the group consisting of a metal, metal oxide, a metal salt, and any combination thereof; and
- 5 an article that, in the absence of said odor reducing composition, emits odor during use, in contact with said odor reducing composition.
19. The article of claim 18 wherein said acid is at least one acid selected from the group consisting of organic acid, amino acid and any combination thereof.
20. The article of claim 18 wherein said metal oxide is at least one selected from
- 10 the group consisting of zinc oxide, copper oxide, iron oxide, manganese oxide, tin oxide and silver oxide.
21. The article of claim 18 wherein said metal is at least one selected from the group consisting of zinc, copper, iron, manganese, tin and silver.
22. The article of claim 18 wherein said salt is at least one selected from the group
- 15 consisting of a salt of zinc, copper, iron, manganese, tin and silver.
23. The article of claim 18 wherein said odor emitting article is selected from the group consisting of pads, tissue, lagoons, bandages, dressings, surgical sponges, personal care articles, cleaning products, room deodorizers, vehicle deodorizers, and garbage bags.
- 20 24. The article of claim 18 wherein said odor reducing composition comprises about (i) 33 to about 99% acid, (ii) about 0.5 to about 40% metal, metal oxide or salt of a metal or metal oxide, and (iii) about 5 to about 50% synthetic zeolite, wherein the sum of (i), (ii) and (iii) is 100%.

25. The article of claim 24 wherein said odor reducing composition comprises about 88 to about 89.5% acid, about 0.5 to about 2% metal, metal oxide or salt of a metal or metal oxide and about 9 to about 11% synthetic zeolite.
26. The article of claim 24 wherein said odor reducing composition comprises
5 about 90 to about 94% acid, about 1 to about 3% metal, metal oxide or salt of a metal or metal oxide and about 5 to about 7% synthetic zeolite.
27. The article of claim 18 wherein said acid and said metal oxide, metal, or salt of metal or metal oxide combined comprise in the range of about 24% to about 99.7% of the total composition and said zeolite comprises in the range of about 0.3% to about
10 76% of the total odor reducing composition.
28. The article of claim 27 wherein said acid and said metal oxide, metal, or salt of metal or metal oxide combined comprise in the range of about 50% to about 98% of the total composition and said zeolite comprises in the range of about 2% to about 50% of the total odor reducing composition.
- 15 29. The article of claim 18 wherein said odor reducing composition further comprises a diluent.
30. The article of claim 29 wherein said diluent is sodium bicarbonate or a natural zeolite.
31. The article of claim 30 wherein said diluent is clinoptilolite.
- 20 32. The article of claim 31 wherein said odor reducing composition comprises about 30-38% aspartic acid or fumaric acid, about 0.5-1% ZnO, about 1-2% zeolite, and about 60-67% clinoptilolite.

33. An odor-controlled article comprising:

- 5 (a) an effective amount of an odor reducing composition for controlling odors, wherein said odor reducing composition comprises (i) at least one acid selected from aspartic, fumaric, sorbic, tartaric or adipic acid, (ii) at least one synthetic zeolite having at least about 90 percent SiO_2 tetrahedra oxide units, a capacity for adsorbed water of not greater than about 10 weight percent when measured at 25°C and at a water vapor pressure at 4.6 torr, and pore apertures at least about 5.5 \AA in diameter, wherein the original water of hydration has been substantially removed, and (iii) zinc oxide or zinc sulfate; and
- 10 (b) an article that, in the absence of said odor reducing composition, emits odor during use, in contact with said odor reducing composition.

34. A method for reducing odor that comprising contacting an effective amount of an odor reducing composition that comprises (a) at least one acid having a pK_a greater than about 2.9 and less than about 6, water solubility less than about $45\text{g}/100\text{g H}_2\text{O}$, and an oral rat LD_{50} greater than about 2200 mg/kg , (b) at least one synthetic zeolite having at least about 90 percent of its tetrahedral oxide units as SiO_2 tetrahedra, a capacity for adsorbed water of not greater than 10 weight percent when measured at 25°C at a water vapor pressure at 4.6 torr, and pore apertures at least 5.5 \AA in diameter, from which the original water of hydration has been substantially removed, and (c) at least one substance selected from the group consisting of a metal, metal oxide, salt of a metal or metal oxide, and any combination thereof, with an article that, in the absence of said odor reducing composition, emits an odor during use, for a

15

20

sufficient time to effectively remove said odor; and removing said emitted odor from said odor emitting article.

35. The method of claim 34 wherein said metal oxide is at least one selected from the group including zinc oxide, copper oxide, iron oxide, manganese oxide, tin oxide
5 and silver oxide.

36. The method of claim 34 wherein said metal is at least one selected from the group consisting of zinc, copper, iron, manganese, tin and silver.

37. The method of claim 34 wherein salt is at least one selected from the group consisting of a salt of zinc, copper, iron, manganese, tin and silver.

10 38. The method of claim 34 wherein said odor emitting article is selected from the group consisting of pads, lagoons, tanks, animal waste, bandages, dressings, surgical sponges, catamenial devices, beef, poultry and fish trays, personal care articles, foot powders, laundry preparations, pet litters, cleaning products, deodorizers, bedding, floors, garbage cans, diaper pails, refrigerators, vehicles, and carpet.

15 39. The method of claim 34 wherein said odor reducing composition comprises about (i) 33 to about 99% acid, (ii) about 0.5 to about 40% metal, metal oxide or salt of a metal or metal oxide, and (iii) about 5 to about 50% synthetic zeolite, wherein the sum of (i), (ii) and (iii) is 100%.

40. The method of claim 39 wherein said odor reducing composition comprises
20 about 88 to about 89.5% acid, about 0.5 to about 2% metal, metal oxide or salt of a metal or metal oxide and about 9 to about 11% synthetic zeolite.

41. The method of claim 39 wherein said odor reducing composition comprises about 90 to about 94% acid, about 1 to about 3% metal, metal oxide or salt of a metal or metal oxide and about 5 to about 7% synthetic zeolite.
42. The method of claim 34 wherein said odor reducing composition comprises
5 said acid and said metal substance in the range of about 24% to about 99.7% of the total composition and said zeolite comprises in the range of about 0.3% to about 76% of the total odor reducing composition.
43. The method of claim 34 wherein said composition comprises in the range of about 50% to about 98% of the total composition and said zeolite comprises in the
10 range of about 2% to about 50% of the total odor reducing composition.
44. The method of claim 34 wherein said odor reducing composition further comprises a diluent.
45. The method of claim 44 wherein said diluent is sodium bicarbonate or a natural zeolite.
- 15 46. The method of claim 45 wherein said diluent is clinoptilolite.
47. The method of claim 46 wherein said odor reducing composition comprises about 30-38% aspartic acid or fumaric acid, about 0.5-1% ZnO, about 1-2% zeolite, and about 60-67% clinoptilolite.
48. A method for removing odor from an odor emitting environment comprising:
20 contacting an effective amount of an odor reducing composition, wherein said odor reducing composition comprises at least one acid having a pK_a greater than about 2.9 and less than about 6, water solubility less than about 45 g/100g H_2O , and an oral rat LD_{50} greater than about 2200 mg/kg, at least one synthetic zeolite having at least

about 90 percent SiO_2 tetrahedra oxide units, a capacity for adsorbed water of not greater than 10 weight percent measured at 25°C and water vapor pressure of 4.6 torr, and pore apertures at least 5.5 in diameter, from which the original water of hydration has been substantially removed, and at least one substance selected from the group

5 consisting of a metal, metal oxide, a metal salt and any combination thereof, with said odor emitting environment; and allowing a sufficient time to pass for said composition to remove the odor.

49. The method of claim 48 wherein said step of contacting an effective amount of an odor reducing composition with said odor emitting environment comprises

10 contacting an odor reducing composition, wherein said composition is contained within an article that allows for containment of said composition with said odor emitting environment.

INTERNATIONAL SEARCH REPORT

Inter national Application No

PCT/US 01/42060

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 A61L9/01 A61L9/014 A61L9/16 A61K7/32 A01K1/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 A61L A61K A01K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the International search (name of data base and, where practical, search terms used)

WPI Data, PAJ, EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 98 27261 A (MOWRY LESLIE ANDERSON ;TORDIL HELEN BERNARDO (US); LIU ZAIYOU (US)) 25 June 1998 (1998-06-25) page 3, line 10 -page 17, line 23 ---	1-7, 18-23, 29,30, 34-38, 44,45, 48,49
X	US 5 911 976 A (BUCKNER ROBIN YAGER ET AL) 15 June 1999 (1999-06-15) column 5, line 45 -column 9, line 4 --- -/--	1-7, 18-23, 29,30, 34-38, 44,45, 48,49



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

* Special categories of cited documents:

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the International filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

G document member of the same patent family

Date of the actual completion of the international search

6 June 2002

Date of mailing of the international search report

12/06/2002

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

De Waha, R

INTERNATIONAL SEARCH REPORT

Inter nal Application No

PCT/US 01/42060

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 00 23120 A (CRUICKSHANK GRAEME DUNCAN ;STODDART BARRY (GB); WONG ALFRED TSZ CH) 27 April 2000 (2000-04-27) page 1, line 15 -page 13, line 19 -----	1-49
A	WO 91 12029 A (PROCTER & GAMBLE) 22 August 1991 (1991-08-22) page 4, line 21 -page 9, line 9 -----	1-49

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 01/42060

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
WO 9827261	A	25-06-1998	BR 9714042 A EP 0946808 A2 WO 9827261 A2 US 6287550 B1	24-10-2000 06-10-1999 25-06-1998 11-09-2001
US 5911976	A	15-06-1999	AU 731790 B2 AU 4908597 A BR 9712657 A CN 1256624 A CZ 9901451 A3 EP 0939614 A1 JP 2002509525 T NO 991896 A TR 9900877 T2 WO 9817239 A1 US 5897856 A	05-04-2001 15-05-1998 26-10-1999 14-06-2000 15-09-1999 08-09-1999 26-03-2002 21-06-1999 21-07-1999 30-04-1998 27-04-1999
WO 0023120	A	27-04-2000	AU 6508399 A AU 6509899 A WO 0023119 A1 WO 0023120 A1	08-05-2000 08-05-2000 27-04-2000 27-04-2000
WO 9112029	A	22-08-1991	AT 142509 T AU 657676 B2 AU 7249991 A BR 9106037 A CA 2071962 A1 CA 2071962 C CN 1054901 A ,B CN 1249953 A DE 69122086 D1 DE 69122086 T2 DK 515477 T3 EP 0515477 A1 ES 2091917 T3 FI 923593 A GR 3020986 T3 HK 1006544 A1 IE 910444 A1 JP 3046064 B2 JP 5503647 T KR 157598 B1 NZ 237071 A PT 96734 A ,B SG 68553 A1 WO 9112029 A1 US 5306487 A	15-09-1996 23-03-1995 03-09-1991 02-03-1993 13-08-1991 20-09-1994 02-10-1991 12-04-2000 17-10-1996 06-02-1997 03-03-1997 02-12-1992 16-11-1996 11-08-1992 31-12-1996 05-03-1999 14-08-1991 29-05-2000 17-06-1993 01-02-1999 25-02-1994 29-11-1991 16-11-1999 22-08-1991 26-04-1994